

Work Order ID ~~77303~~

December-05-11 9:02:35 AM

**\*77303\***

Page 1

Item ID: D3686-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: MONOPOD ASSEMBLY

Start Date: 12/02/11 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 12/02/11 Req'd Qty: 2.00 **\*2\***

Customer:

Reference: ECN11-676 **REWORK**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3686

E

110

0.00

**\*110\***

Small Fab

Small Fab

0.00

Small Fab

Memo

PULL FROM STOCK:

2 x D3686-041-B72001

REMOVE AN3C12A BOLTS-DISCARD

REPLACE WITH

2 X MS21250-03014 B **M119902**

PER DSI 9571

1-Use anti-seize compound Tectly 502c Class 1.Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF THREAD\*\*\*\*\*

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

\*\*\*Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

*Handwritten signature and date: 12/12/12 (2)*

**Work Order ID 77303**

December-05-11 9:02:35 AM

**\*77303\***

Page 2

Item ID: D3686-041

Revision ID:

Item Name: MONOPOD ASSEMBLY

Start Date: 12/02/11 Start Qty: 2.00

Required Date: 12/02/11 Req'd Qty: 2.00

Reference: ECN11-676

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 077

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*Per 11/12/12**11/12/13*  
*MF*  
*11-12-13*

# Picklist Print

December-05-11 9:02:34 AM

Page 1

Work Order ID: 77303  
Parent Item: D3686-041  
Parent Item Name: MONOPOD ASSEMBLY

Start Date: 12/02/11  
Start Qty: 2.00

Required Date: 12/02/11  
Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM  
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
03-16 JLM VERIFIED BY:EC  
IPP Rev:D Added sealant note as per Rev C 09-01-20 JLM  
Verf:DD  
revE DD verf:EC  
IPP REV:C AS PER REV D 10-  
IPP REV:E 11.12.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D3686-041</del> MONOPOD ASSEMBLY		Manufactured	No				Each	0.0000	72001	2	4511/12/12		
<del>MS21250-03014</del> BOLT		Purchased	No				Each	0.0000	M119902	4	4511/12/12		

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-770 REV. C  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-770 REV. 2

REF. TCCA STC: SH08-8

REF. FAA STC: SR02690NY / SR02070SE

REF. EASA STC: EASA.IM.R.S.01528

## 1.0 PURPOSE

On D205-770-011 Replacement Engine Mount Kits at CHG 004 or later, the AN3C12A Bolts on the bottom of the D3686-041 Monopod Assembly are replaced with MS21250-03014 Bolts to prevent premature bolt failure in service. Customers with D205-770-011 Replacement Engine Mount Kits at CHG 003 or earlier are encouraged to procure the DSI 9571-011 Kit from Dart to upgrade their existing kits.

## 2.0 INSTALLATION

- 2.1 Temporarily suspend the weight of the engine using appropriate hoist and engine sling.
- 2.2 Unfasten qty(2) AN3C12A Bolts as shown in Figure 1 of this service instruction. Retain the D3692-1 Spacers and discard the AN3C12A Bolts and MS21043-3 Nuts.
- 2.3 Inspect the bearings for looseness in accordance with Section 5.1 of ICA-D205-770.
- 2.4 Install the MS21250-03014 Steel Tension Bolts, D3692-1 Spacers and MS21042-3 Nuts as shown in Figure 2 and ensure that the D3692-1 Spacers are correctly oriented along the face of the stud.
- 2.5 Torque bolts to 20 to 25 in-lbs (2.3 to 2.8 N-m).
- 2.6 Remove hoist and engine sling.






## 3.0 PARTS LIST

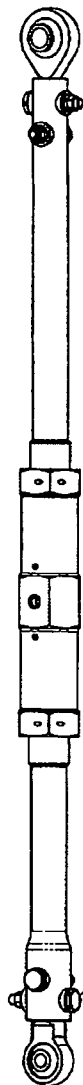
Qty -011	Part Number	Description
X	DSI 9571-011	BOLT SUBSTITUTION KIT
2	MS21042-3	NUT (OR MS21042L3)
2	MS21250-03014	STEEL TENSION BOLT

## 4.0 WEIGHT & BALANCE

This change has negligible effect on weight and balance

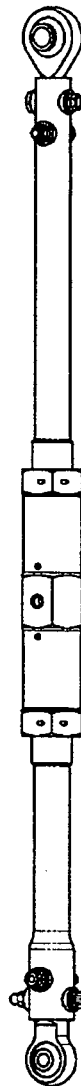
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-Q-01	
APPROVED  BY: D. SHEPHERD (DE # 02)	
DATE:	11.11.28
CERT. NO.:	SH08-8
ISSUE NO.:	1

B	PRODUCT IMPROVEMENT: PERMANENT CHANGE. (REF. NCR11-754)	MB	11.11.23
A	NEW ISSUE	MB	11.09.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. B DSI 9571 SHEET 1 OF 2	
CHECKED		TITLE SCALE BOLT SUBSTITUTION NTS	
MFG. APPR.	N/A	DATE 11.11.23	
APPROVED		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.			



AN3C12A BOLT  
D3692-1 SPACER, 2X  
MS21043-3 NUT  
2 PL

**FIGURE 1 (WAS)**



MS21250-03014 BOLT  
D3692-1 SPACER, 2X  
MS21042-3 NUT  
2 PL

**FIGURE 2 (IS)**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 11.11.28  
CERT. NO.: SH08-8  
ISSUE NO.: 1

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9571	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT SUBSTITUTION	NTS
DATE	11.11.23	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	